

Date: Tuesday, 12/12/2006 10:30:00 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : LUG
 Job Number : 29887
 Estimate Number : 11049
 P.O. Number : N/A Part Number : D2847
 This Issue : 12/12/2006 S.O. No. : N/A Drawing Number : D2847 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : N/A Material : N/A
 Due Date : 12/22/2006 Qty: 30 Um: Each
 Written By : JA 06/12/12
 Checked & Approved By : JA 06/12/12
 Comment : Est F00.96.22 Removed P/O for powder coat EC

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B0375X02000 6061-T6 Bar .375 x 2.0"



Comment: Qty.: 0.1400 f(s)/Unit Total: 4.1990 f(s)
 6061-T6 Bar .375 x 2.0"

Material: 6061-T6 or 6061-T651 Aluminum (QQ-A-255/8 or QQ-A-200/8 or QQ-A-250/11) 2.000" x 0.375"
 Thick Batch: M5785

2.0 BAND SAW BAND SAW



Comment: BAND SAW

Cut blanks: 6.25"

Note: 1 Blank makes 4 parts

J.L 06/12/20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 Machine per folio D2847

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.F. / J.L 06/12/20 (42)

J.F. / J.L 06/12/20 (42)

Final 4.1 QC8 Second Check.
06-12-20.

SA 06.12.21 (42)

W/O: -		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description:

5.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble to remove rough edges

Debur any rough edges after tumbling

FF 07-01-23

PFO
(41)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-A/

07/01/24

(41X)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

For N/A

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

ml 07 01 24

(41)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M103141

M-A/yl

07/01/25

(41X)

counted

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 7/1/25

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 389

CB 07/01/25 (41) 10

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

07/01/26

(41)

Job Completion



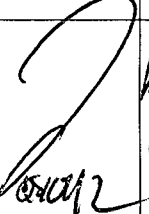



W 07/01/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/01/23
 QA: N/C Closed: _____ Date: _____

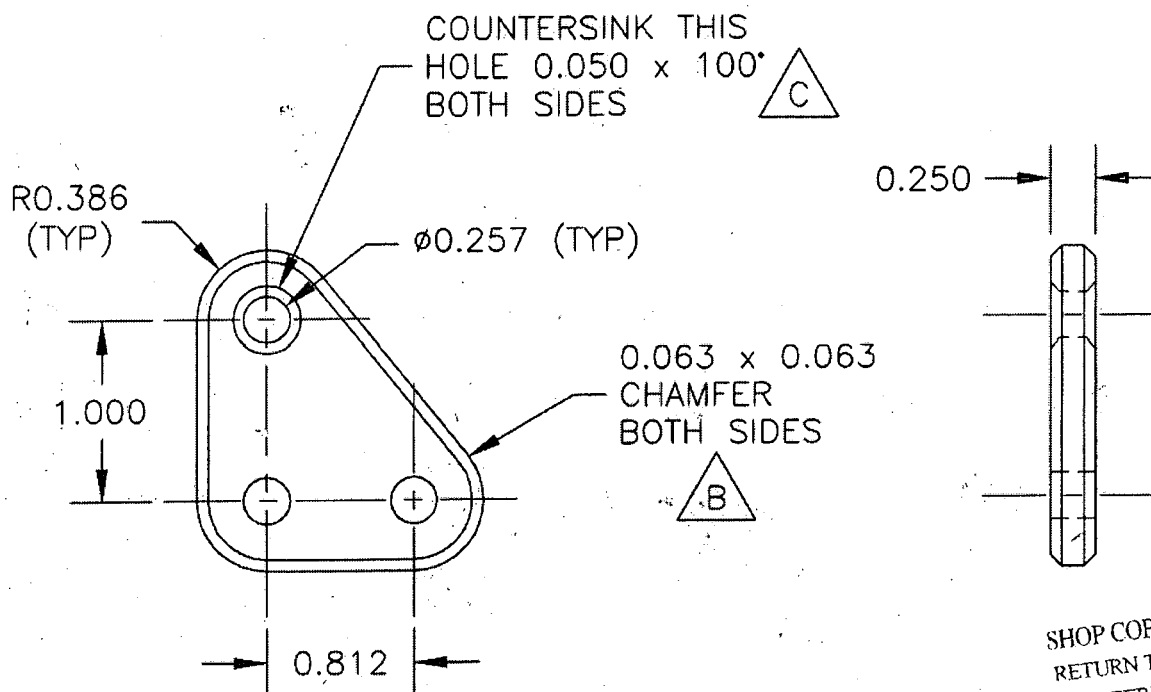
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
07-01-23	5	COUNTER sunk was wrong Hole		Destroy	07-01-23 FF	 07/01/23	 07/01/23	 07/01/23

NOTE: Date & initial all entries



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED JH	APPROVED JH	DRAWING NO. D2847	REV. C SHEET 1 OF 1
DATE 99.02.15		TITLE LUG	SCALE 1:1
A	98.11.04	NEW ISSUE	
B	99.01.07	ADD CHAMFER	
C	99.02.15	ADD COUNTERSINK	

RELEASED
99.03.01 KE



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 29887

MATERIAL: 6061-T6 OR 6061-T651 (QQ-A-225/8 OR QQ-A-200/8 OR QQ-A-250/11)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED